

Date: Monday, 11/02/2008 10:54:59 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FILLER
Job Number : 37312	
Estimate Number : 10782	
P.O. Number :	Part Number : D32087
This Issue : 11/02/2008 S.O. No. :	Drawing Number : D3208 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 35832	Material :
Written By :	Due Date : 14/02/2008 Qty: 12 Um: Each
Checked & Approved By :	
Comment : Est: B04.05.25 Material changed for Step 4KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.0947 sf(s)/Unit Total : 1.1365 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.040" thick
(M2024T3S.040)
Batch: 103321 IB 8-2-11

2.0	SHEAR	SHEAR
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Comment: SHEAR
Cut blank: 2.750" x 4.300"
Identify for D3208-7
A IB 8-2-11

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Drill and Fillet D3208-7 corner as per Dwg D3208
Identify as D3208-7

Done at water jet
step 2
N/A
01/02/13

4.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Deburr D3208-7
Polish any marks on part within 01. of Dwg D3208

08/02/12 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3208-7 PAR #: NA Fault Category: Prod / Eng. ASS. med & Small NCR: Yes No DQA: D Date: 08/02/14
 QA: N/C Closed: HA Date: 08/02/14

NCR: <u>37312</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/02/14</u>	<u>#20</u>	<u>one part scrap cut out from water tub at the hole location R.C. machine malfunction</u>	<u>[Signature]</u> <u>08/02/14</u>	<u>Scrap and Destroy no replace <u>Qty x 1</u></u>	<u>AS</u> <u>8-2-14</u>	<u>[Signature]</u> <u>08/02/14</u>	<u>[Signature]</u> <u>08/02/14</u>	<u>[Signature]</u> <u>08/02/14</u>

NOTE: Date & initial all entries

Date: Monday, 11/02/2008 10:54:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FILLER

Job Number: 37312

Part Number: D32087

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/12 (19)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-02-12

(19)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

08-02-12

(19)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 200

JS 08/02/13

(19)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.02.13 (19)

Job Completion



2008/2/13

(19)

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

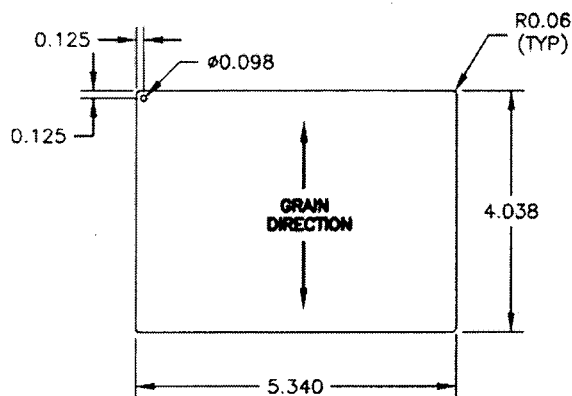
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

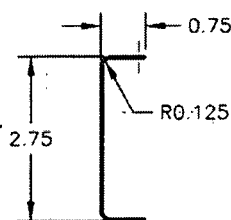


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CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
A	04.01.27	NEW ISSUE	
A1	04.05.25	CHANGE DIM; NOTE 3) CHANGE	

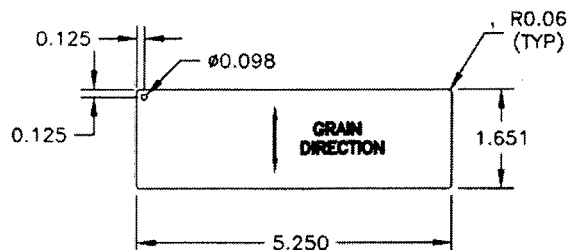
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04 04 05



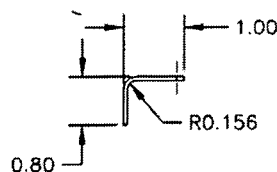
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



A1 MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)

WLO
37312

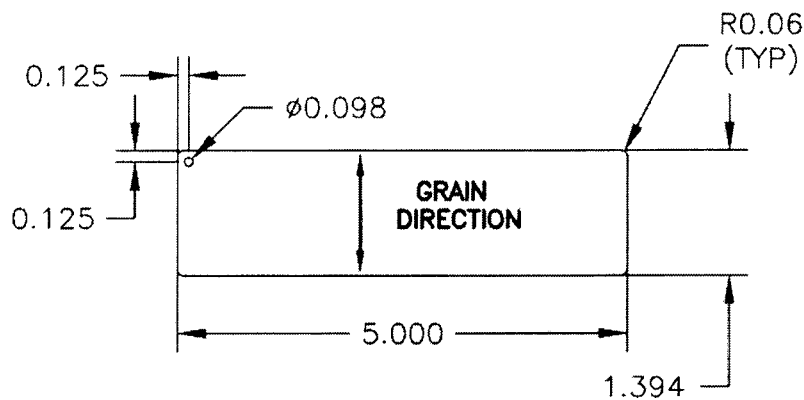
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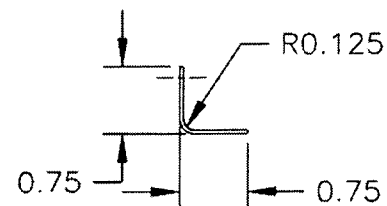


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3208	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

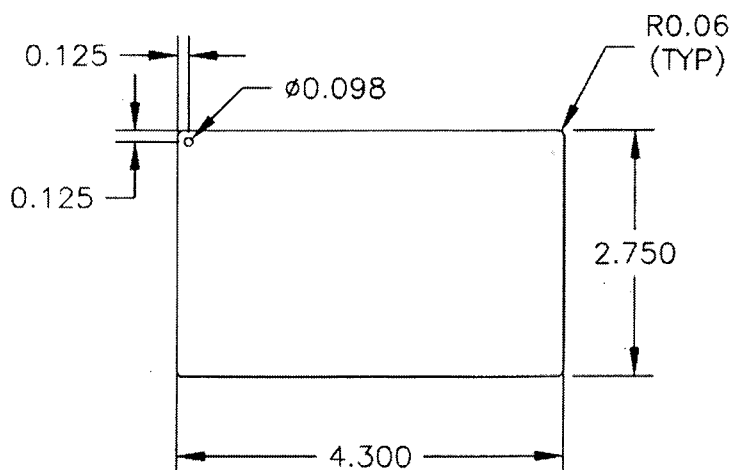
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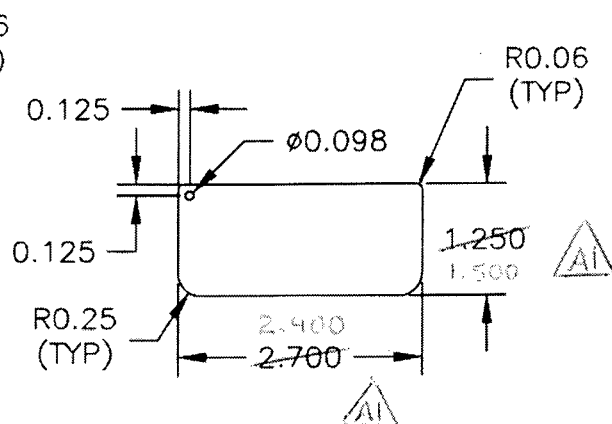
2 D3208-5 MOUNT ANGLE
FLAT PATTERN



D3208-5 MOUNT ANGLE
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

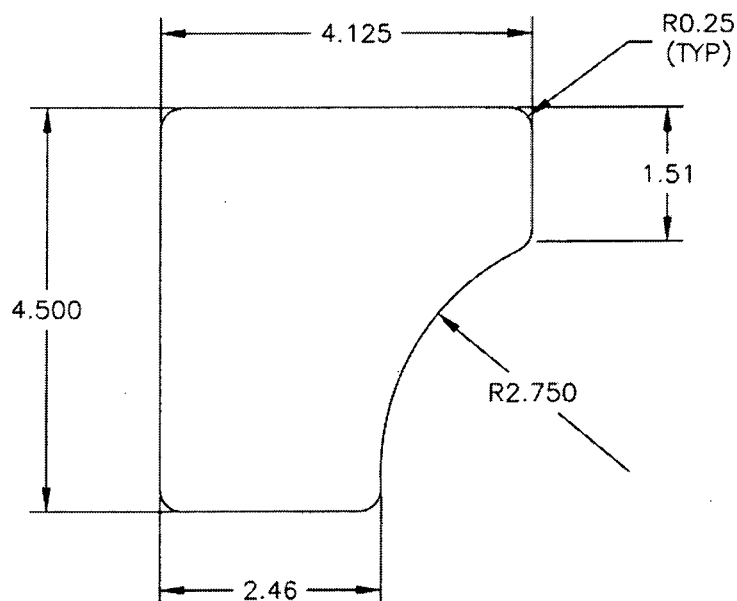
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DESIGN RT	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED
04.01.05



D3208-9 DOUBLER

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DART AEROSPACE LTD		Work Order:	37362
Description: FILLER		Part Number:	D3208-7
Inspection Dwg: D3208-7 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X

Prototype

[illegible]

Measured by:	LB
Date:	8-2-11

Audited by:	<i>[Signature]</i>
Date:	08/2/12

Prototype Approval:	<i>a</i>
Date:	<i>7</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	